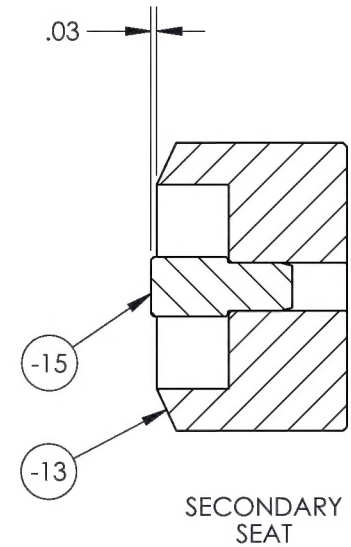
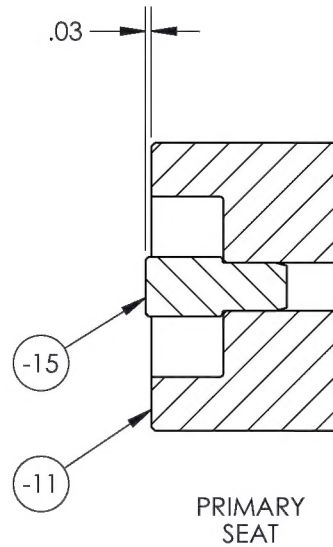
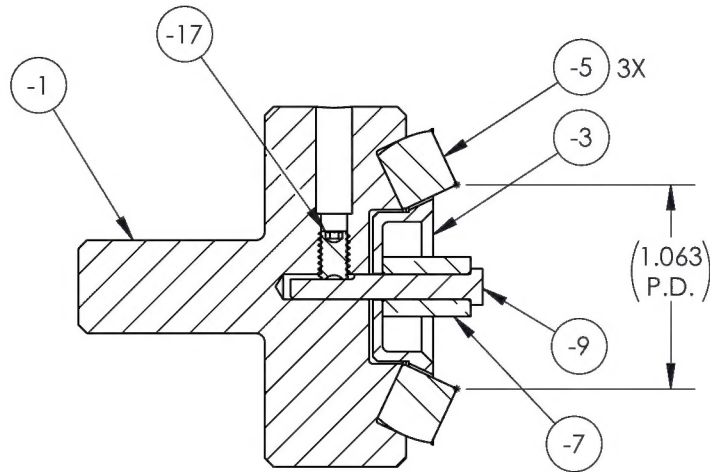
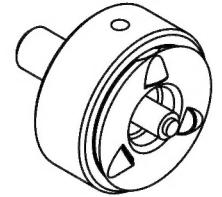


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	4/6/2017	DPD	JAG



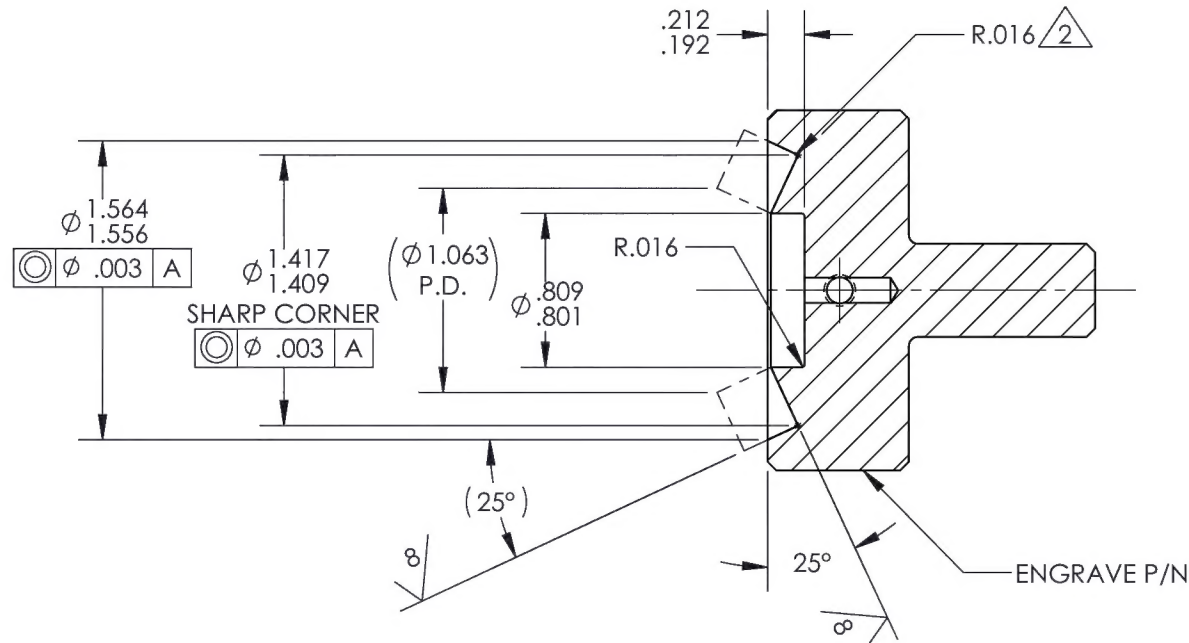
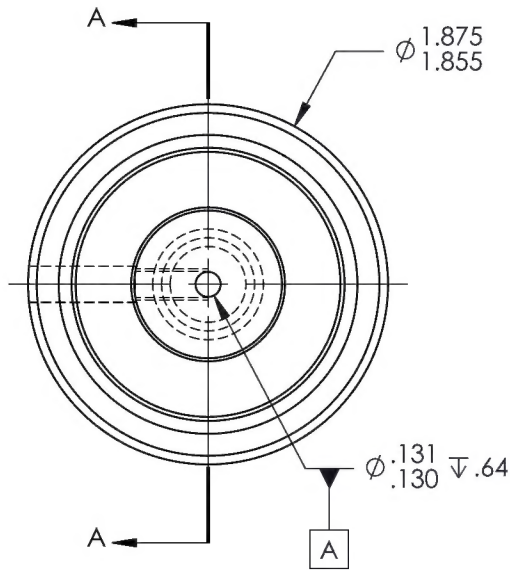
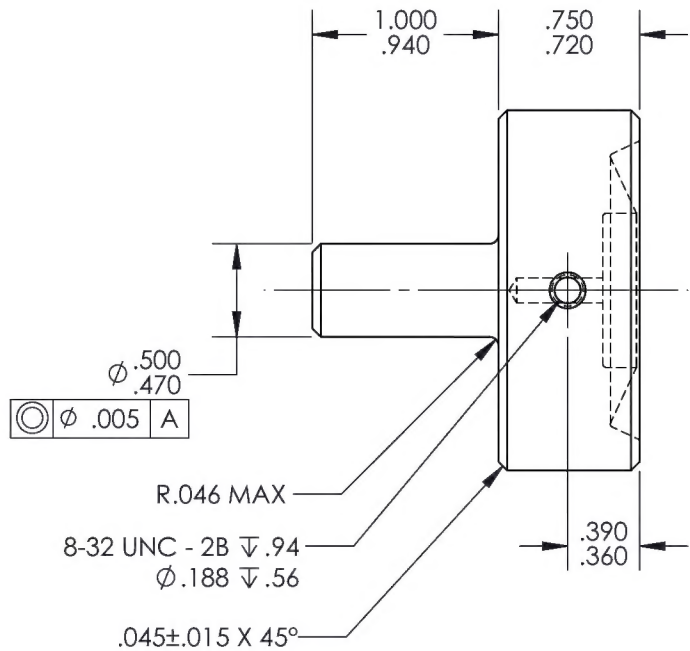
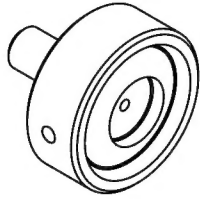
NOTE:  
USED FOR BEARING 412-010-182-103.

<b>DART AEROSPACE</b>	
TITLE <b>DRILL PRESS SWAGING TOOL</b>	
DWG NO. <b>RBST4241</b>	REV <b>1</b>
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125° ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL	
DRAWN BY: DD 04/05/2017	QA APPR: JL 04/05/2017
CHECKED: SM 04/05/2017	APPROVED: JAG 04/06/2017
SCALE 1:1	DATE 4/5/2017
SHEET 1 OF 9	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	ROLLER FIXTURE	0-1 DRILL ROD		2
			-3	1	RETAINER	BRONZE		3
			-5	3	ROLLER	STEEL	Ø.031, CLASS ZZ, MINUS (GAUGE PIN MSC #89031009) MODIFIED	4
			-7	1	GUIDE	BRONZE		5
			-9	1	PIN	STEEL	Ø.129 X 2-1/2 (MCMaster-CARR #98378A909) MODIFIED	6
			-11	1	PRIMARY SEAT	4140/4142		7
			-13	1	SECONDARY SEAT	4140/4142		8
			-15	2	LOCATING PIN	1018/1020 CR		9
		B/O	-17	1	SOCKET HEAD SET SCREW	S.S.	#8-32 X 1/4 (MCMaster-CARR #97705A406)	1

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APPROVED				



SECTION A-A

- NOTES:
- BREAK ALL SHARP CORNERS .015-.030
  - DIMENSION TO BOTTOM OF R.016=.153; DIMENSION TO SHARP CORNER=.158.
  - DO FIRST ARTICLE INSPECTION BEFORE HEAT TREATING.



TITLE  
DRILL PRESS SWAGING TOOL

DWG NO. RBST4241-1

REV  
1

MAT'L 0-1 DRILL ROD

HEAT TREAT RC 55-60

FINISH ZINC PLATE

SPEC QMSI-6.2.2, B.O. REV D

DRAWN BY: DD 04/05/2017

CHECKED: SM 04/05/2017

OPPS APPR: AA 04/05/2017

QA APPR: JL 04/05/2017

APPROVED: JAG 04/06/2017

SCALE 1:1

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES  
.XXX  $\pm .005$  FRACTIONS  $\pm 1/8$   
.XX  $\pm .01$  ANGLES  $\pm .5^\circ$   
.X  $\pm .1$  SURFACES = 125/ $\sqrt{\text{ }}$

- BREAK ALL SHARP EDGES .015 x 45° OR .015R
- DIMENSIONAL LIMITS APPLY AFTER PLATING
- INTERPRET DIM AND TOL PER ASME Y14.5M-2009

USED ON MODEL

DATE 4/5/2017

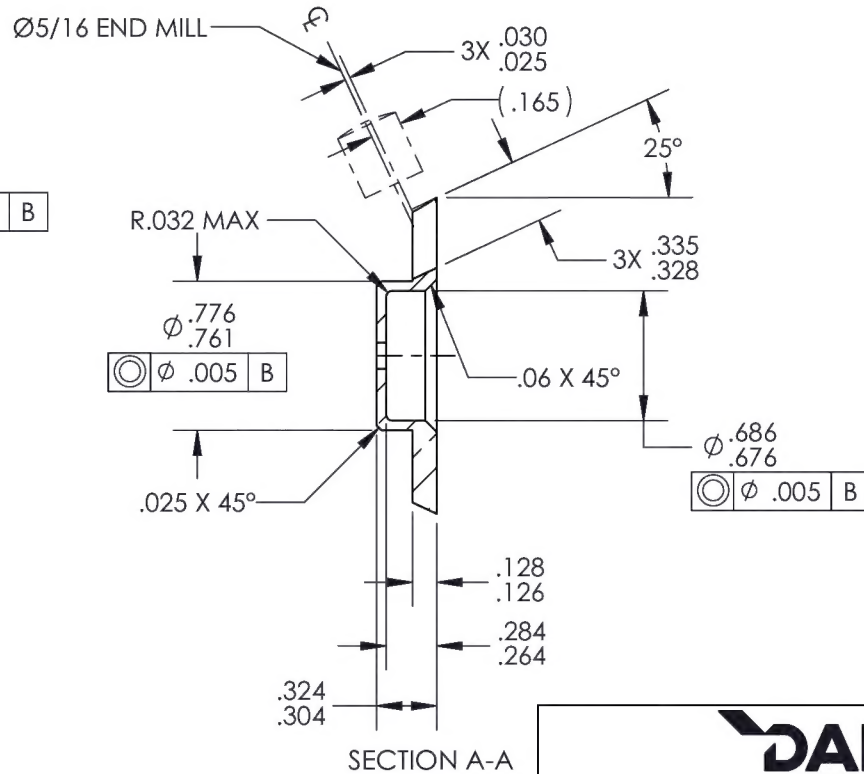
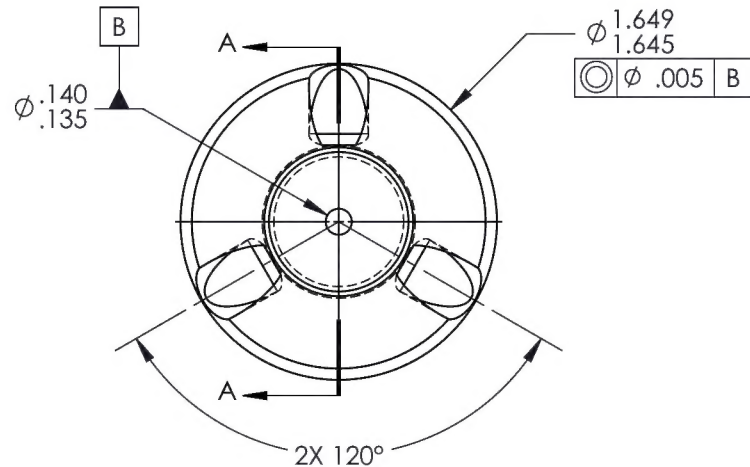
SHEET 2 OF 9

-1

ROLLER FIXTURE

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REV	ECR	DESCRIPTION	DATE
			INITIAL
			APPROVED

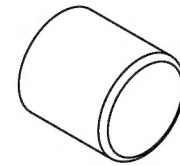
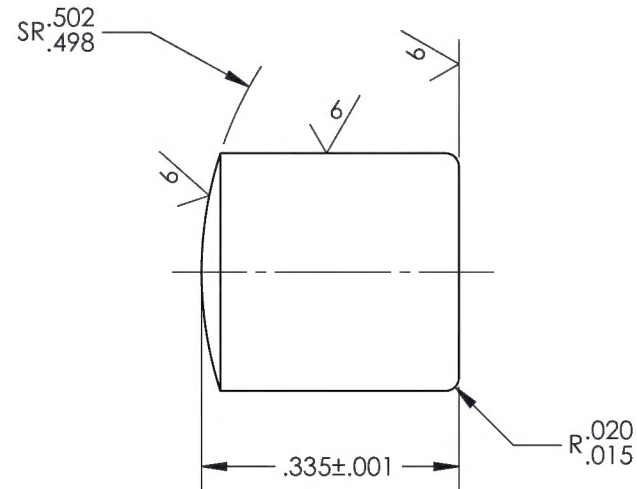
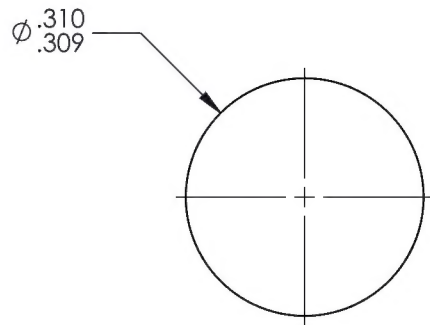


(-3)  
RETAINER

<b>DART AEROSPACE</b>	
TITLE <b>DRILL PRESS SWAGING TOOL</b>	
DWG NO. <b>RBST4241-3</b>	REV <b>1</b>
MAT'L BRONZE	UNLESS OTHERWISE SPECIFIED
TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX $\pm$ .005 FRACTIONS $\pm$ 1/8
SPEC	.XX $\pm$ .01 ANGLES $\pm$ 5°
	.X $\pm$ .1 SURFACES = 125 $\sqrt$
DRAWN BY: DD 04/05/2017	1. BREAK ALL SHARP EDGES
CHECKED: SM 04/05/2017	.015 x 45° OR .015R
OPPS APPR: AA 04/05/2017	2. DIMENSIONAL LIMITS APPLY
QA APPR: JL 04/05/2017	AFTER PLATING
APPROVED: JAG 04/06/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:1	DATE 4/5/2017
	SHEET 3 OF 9

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REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED

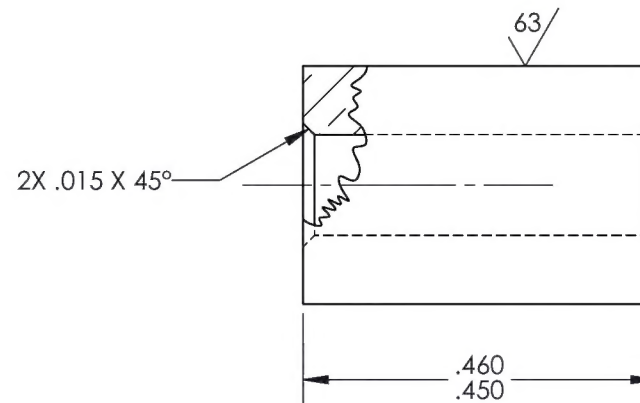
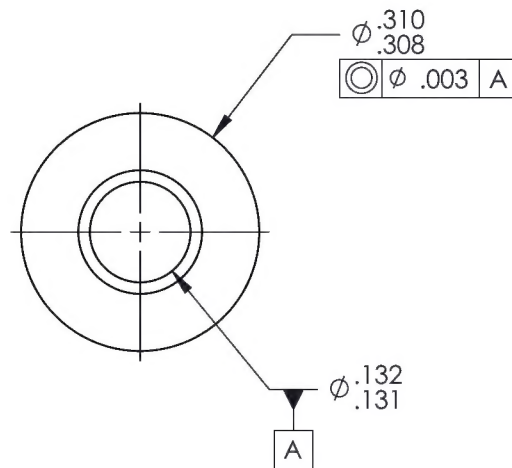
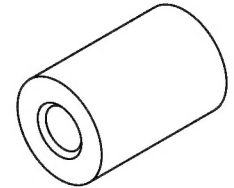


(-5)  
ROLLER

<b>DART AEROSPACE</b>	
TITLE <b>DRILL PRESS SWAGING TOOL</b>	
DWG NO. <b>RBST4241-5</b>	REV <b>1</b>
MAT'L STEEL HEAT TREAT RC 55-60 FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: DD 04/05/2017	USED ON MODEL
CHECKED: SM 04/05/2017	
OPPS APPR: AA 04/05/2017	
QA APPR: JL 04/05/2017	
APPROVED: JAG 04/06/2017	
SCALE 4:1	DATE 4/5/2017
SHEET 4 OF 9	

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NOTE:  
BREAK ALL SHARP CORNERS .015 - .030.



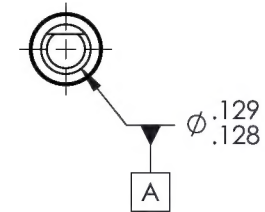
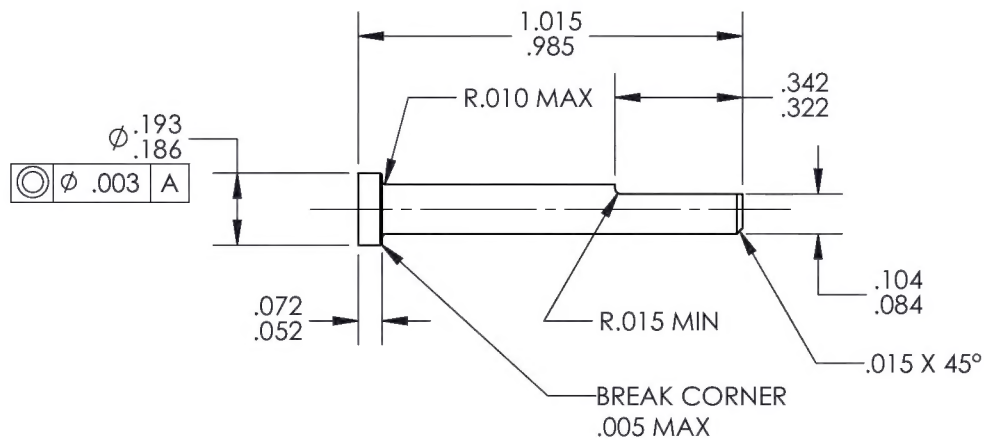
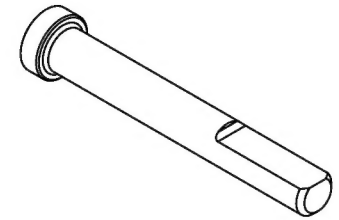
TITLE		DRILL PRESS SWAGING TOOL	
DWG NO.		RBST4241-7	
REV		1	
MAT'L BRONZE		UNLESS OTHERWISE SPECIFIED	
TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX $\pm$ .005 FRACTIONS $\pm$ 1/8	
SPEC		.XX $\pm$ .01 ANGLES $\pm$ 5°	
DRAWN BY: DD 04/05/2017		.X $\pm$ .1 SURFACES = 125	
CHECKED: SM 04/05/2017		1. BREAK ALL SHARP EDGES	
OPPS APPR: AA 04/05/2017		.015 x 45° OR .015R	
QA APPR: JL 04/05/2017		2. DIMENSIONAL LIMITS APPLY	
APPROVED: JAG 04/06/2017		AFTER PLATING	
SCALE		4:1	
DATE		4/5/2017	
SHEET		5 OF 9	

(-7)

GUIDE

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(-9)

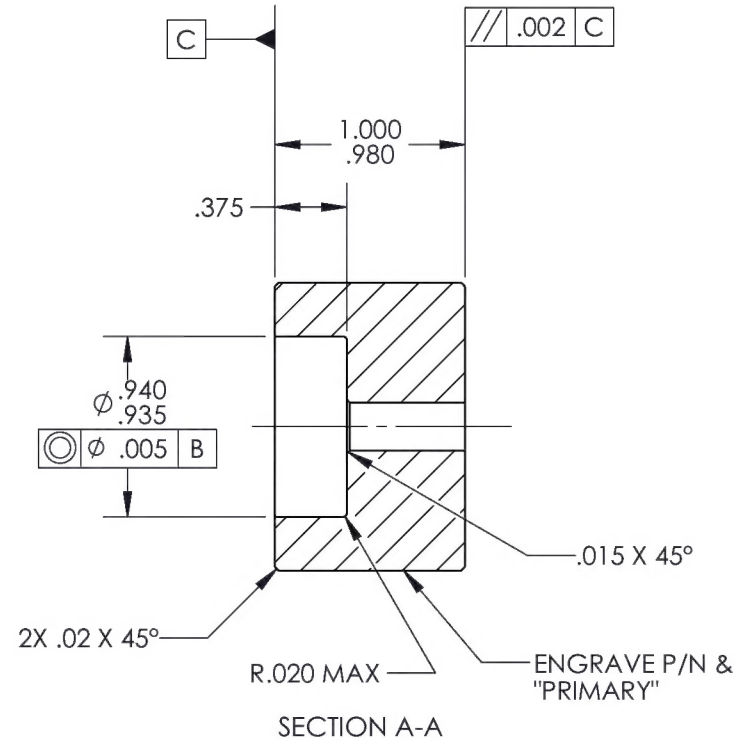
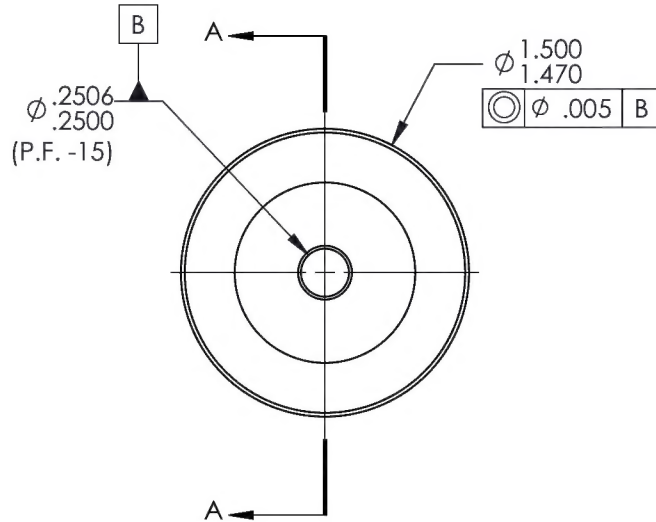
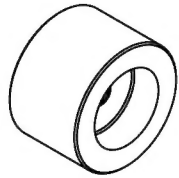
PIN

<b>DART</b> AEROSPACE	
TITLE <b>DRILL PRESS SWAGING TOOL</b>	
DWG NO. <b>RBST4241-9</b>	REV <b>1</b>
MAT'L STEEL HEAT TREAT FINISH BLACK OXIDE SPEC QMSI-6.2.2, B.O. REV D	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX $\pm$ .005 FRACTIONS $\pm$ 1/8 .XX $\pm$ .01 ANGLES $\pm$ 5° .X $\pm$ .1 SURFACES = 125°	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: DD 04/05/2017	USED ON MODEL
CHECKED: SM 04/05/2017	
OPPS APPR: AA 04/05/2017	
QA APPR: JL 04/05/2017	
APPROVED: JAG 04/06/2017	
SCALE 2:1	DATE 4/5/2017
SHEET 6 OF 9	



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				APPROVED



NOTE:  
BREAK ALL SHARP EDGES .015 - .030.

<b>DART</b> AEROSPACE	
TITLE <b>DRILL PRESS SWAGING TOOL</b>	
DWG NO. <b>RBST4241-11</b>	REV <b>1</b>
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT RC 28-34	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX $\pm$ .005 FRACTIONS $\pm$ 1/8
SPEC QMSI-6.2.2, B.O. REV D	.XX $\pm$ .01 ANGLES $\pm$ 5°
DRAWN BY: DD 04/05/2017	.X $\pm$ .1 SURFACES = 125✓
CHECKED: SM 04/05/2017	1. BREAK ALL SHARP EDGES
OPPS APPR: AA 04/05/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
QA APPR: JL 04/05/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED: JAG 04/06/2017	USED ON MODEL
SCALE 1:1	DATE 4/5/2017
SHEET 7 OF 9	

(-11)

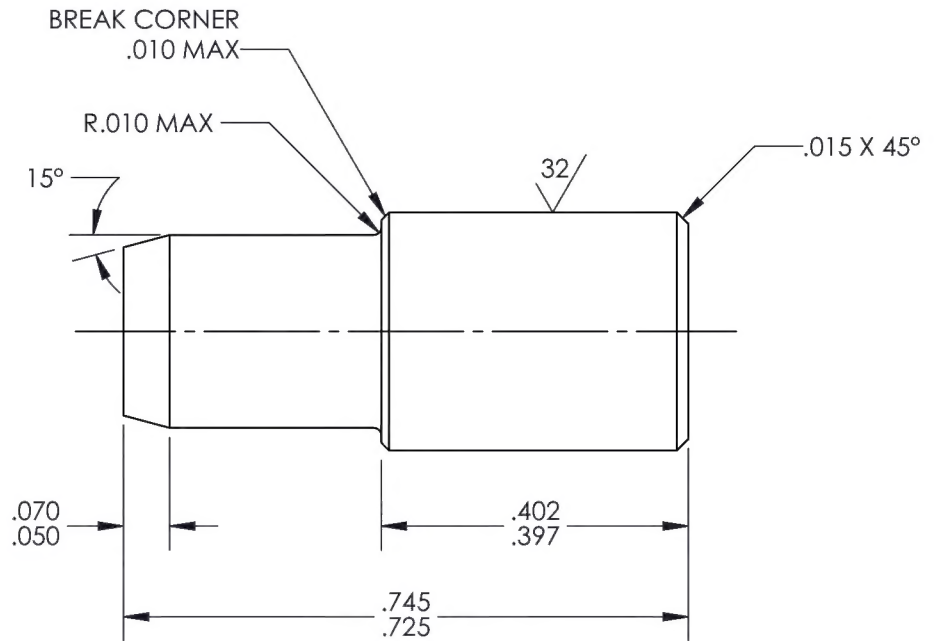
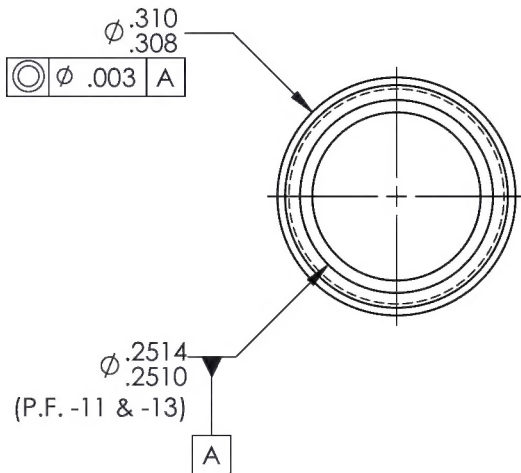
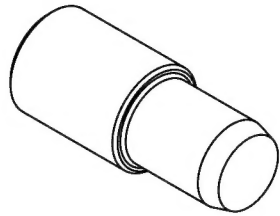
PRIMARY SEAT





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				APPROVED



(-15)  
LOCATING PIN

<b>DART AEROSPACE</b>	
TITLE <b>DRILL PRESS SWAGING TOOL</b>	
DWG NO. <b>RBST4241-15</b>	REV <b>1</b>
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC QMSI-6.2.2, B.O. REV D	.XX ± .01 ANGLES ± 5°
DRAWN BY: DD 04/05/2017	.X ± .1 SURFACES = 125/
CHECKED: SM 04/05/2017	1. BREAK ALL SHARP EDGES
OPPS APPR: AA 04/05/2017	.015 x 45° OR .015R
QA APPR: JL 04/05/2017	2. DIMENSIONAL LIMITS APPLY
APPROVED: JAG 04/06/2017	AFTER PLATING
SCALE 4:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 4/5/2017	USED ON MODEL
SHEET 9 OF 9	